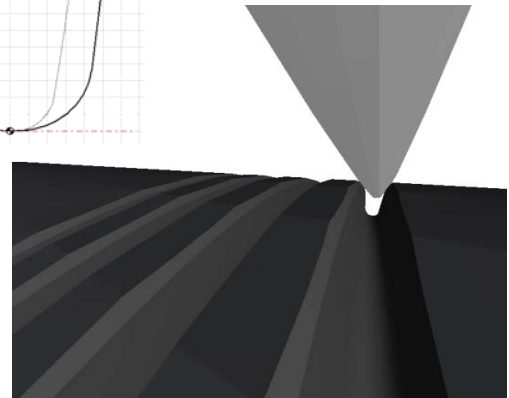
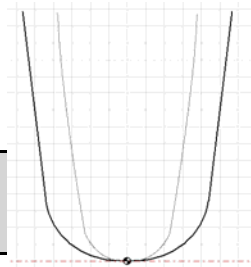
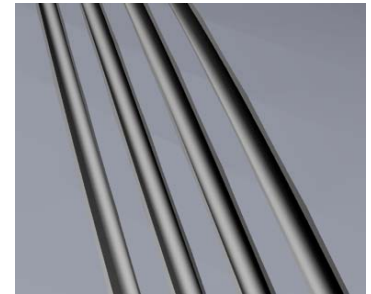
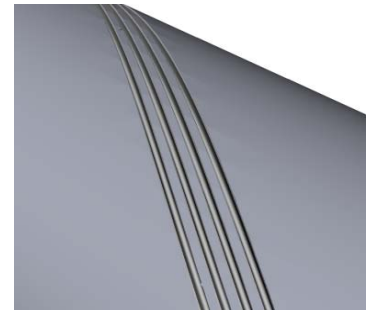
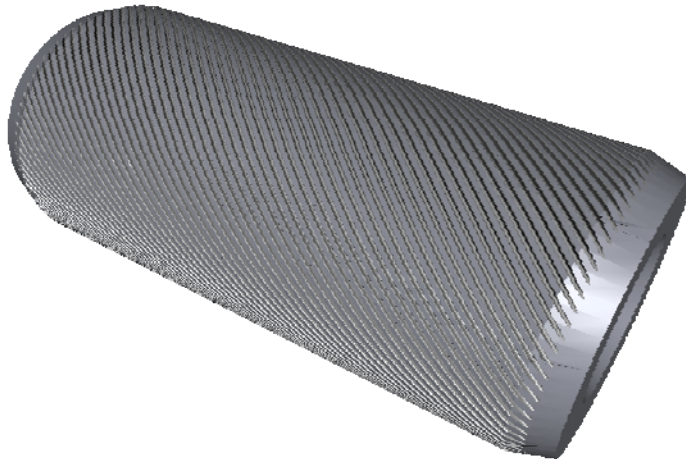
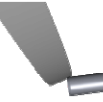

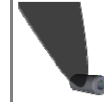
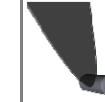






## Grooving Plug Ø8.2 L17 Z80

A30-010



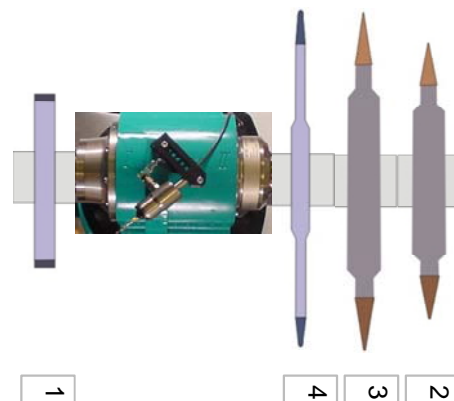
### 1. Cycletime for Production

Workpiece: Ø8.2 L17 ID4.0 Material HSS	Chamfers: cyl. grinding oscillating grooves: 1 pass rough, 6 passes finish grooves chamfers: 1 pass			
Operations				
	Chamfers	Groove Rough	Groove Finish	Groove Chamf.
Feed [mm/Min]	150	120	500	300
Power [kW]	1	1	1	1
Cutting speed [m/s]	32	32	32	32
Used wheels				
	1	2	3	4
Grinding time [s]	272	1028	1729	444
Total cycle time	57 Min 53			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø125 B54
2	14EE1 Ø125 B46V90°
3	14EE1 Ø150 B46V12°
4	14EE1 Ø150 B25V12°



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA, NGC

Control: Fanuc 31i

Accessories:

Responsible engineer: OP, 22.9.14

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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